

Work Order ID 86600

86600

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CL Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	C

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	***Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ***								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									



12/05/13

12/08/10 JB

1A ✓ M n/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86600

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 8/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00	PP	85325					
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS 12108122

MCS 12108122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Work Order ID: 86600

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC
IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 Placard, Max Load		Manufactured	No				Each	11.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST093		11							
				72051		1							
				84416		10							
D2530 Handle Weldment		Manufactured	No			100	Each	6.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		6							
				82895		1							
				83423		1							
				85779		4							
D2535 Spring		Manufactured	No			100	Each	155.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		155							
				83545		50							
				86333		105							
D2537 Bushing		Manufactured	No			100	Each	18.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		18							
				82896		18							
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000		1			
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000		1			

84416

86621

83545

1188834 (x1) 11/08/10

86596

87238 (x1) 12/08/11

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NOTE: Date & initial all entries

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Work Order ID: 86600

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No 100 Each 51.0000
Washer

6 87405⁶ JB

Location	Loc Qty	Loc Code
FP	5	
85028	5	
ST070	46	
84773	6	
85780	40	

D3953-3 Manufactured No 100 Each 29.0000
Gas Spring Stud, Lid

2 2 JB

Location	Loc Qty	Loc Code
ST075	29	
85788	29	

85788
2 2 JB

D3953-7 Manufactured No 100 Each 37.0000
Spring Spacer

Location	Loc Qty	Loc Code
ST075	37	
82940	7	
85789	30	

85789
2 2 JB

D3953-9 Manufactured No 100 Each 17.0000
Gas Spring Washer

Location	Loc Qty	Loc Code
ST075	17	
82941	17	

2 2 JB 12/08/10

D3953-17 Manufactured No 100 Each 29.0000
Gas Spring Spacer

Location	Loc Qty	Loc Code
ST075	29	
82937	5	
85787	24	

85787

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86600

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3953-19	Manufactured	No	100	Each	30.0000	1	1	✓ JB
Gas Spring Bracket								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST075	30					
		82938	30					82939
D3953-21	Manufactured	No	100	Each	45.0000	1	1	✓ JB
Gas Spring Bracket								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST075	45					
		85718	25					85718
		85759	20					
D3969-3	Manufactured	No	100	Each	38.0000	1	1	✓ JB
Spring (Basket Lid)								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST272	38					
		64285	1					
		82942	37					82942
AN3-14A	Purchased	No	100	Each	137.0000	4	4	✓ JB
Bolt								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST352	137					
		121708	50					
		122141	87					122141
AN3-16A	Purchased	No	100	Each	99.0000	2	2	✓ JB 12/08/10
Bolt								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST352	99					
		117441	47					
		118628	1					
		120986	1					
		121708	50					121708

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86600

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Bolt	Purchased	No	100	Each	140.0000	4	4	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			338	4				
			121181	4				
			ST338	136				
			117872	34				
			121541	2				
			122151	100		122151		
AN4-12 Bolt	Purchased	No	100	Each	79.0000	3	3	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST357	79				
			118626	1				
			121652	28				
			122141	50		122141		
AN310-4 NUT	Purchased	No	100	Each	98.0000	3	3	✓ JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST344	98				
			121349	2				
			121827	96		121827		
AN310C4 Nut	Purchased	No	100	Each	65.0000	2	2	✓ JB 12/08/10
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST344	65				
			120360	1				
			121166	3				
			121444	22				
			122151	39		122151		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 86600

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 100 Each 3,324.0000 6 6 ✓ JB

Nut

Location	Loc Qty	Loc Code
ST300	1324	
117885	32	
119017	771	
119075	138	
121444	383	
ST317	2000	
122141	2000	122141

MS21042L5 Purchased No 100 Each 1,218.0000 4 4 ✓ JB

Nut

Location	Loc Qty	Loc Code
300	500	
121652	500	
ST300	718	
108827	4	
116105	5	
116548	43	
119109	654	119109
17651	4	
2937	8	

MS24665-151 Purchased No 100 Each 170.0000 3 3 ✓ JB

Cotter Pin

Location	Loc Qty	Loc Code
ST309	170	
17566	170	17566

MS24665-300 Purchased No 100 Each 137.0000 2 2 ✓ JB 12/08/10

Cotter Pin

Location	Loc Qty	Loc Code
GA	133	
118234	133	118234
ST309	4	
116823	4	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P	Purchased	No	100	Each	1,258.0000	6	6	✓ JB
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	1258	
121350	258	
122151	1000	

122151

NAS1149F0563P	Purchased	No	100	Each	944.0000	4	4	✓ JB
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	944	
121350	944	

121350

NAS1149F0332P	Purchased	No	100	Each	1,010.0000	8	8	✓ JB
WASHER								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	1010	
117735	13	
119225	10	
120986	170	
121259	200	
121825	14	
122063	600	
17317	3	

120986

NAS1149C0432R	Purchased	No	100	Each	3,402.0000	2	2	✓ JB 12/08/10
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	1070	
117291	70	
119124	1000	
ST298	2332	
121255	2332	

121255

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

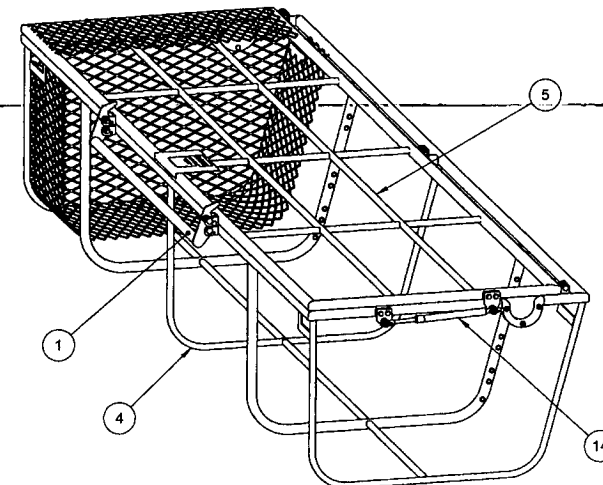
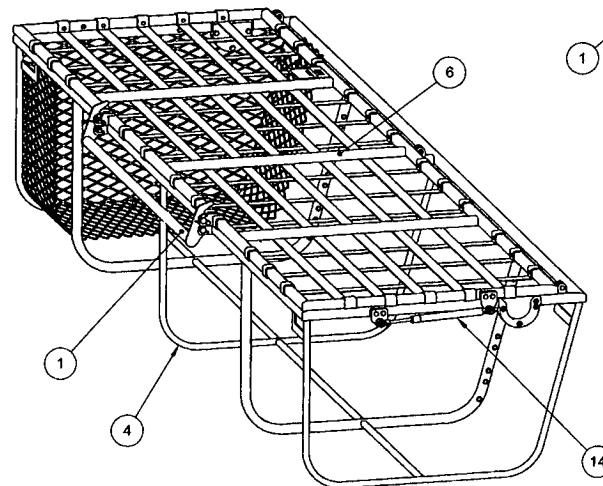
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

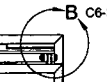
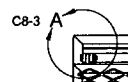
C/L 12107105
W10: 86600

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.08.12.07
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3).	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	JFS		
APPROVED			
DE APPR.			
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 REV. C SHEET 1 OF 3 TITLE LONG BASKET ASSY (350) SCALE NTS. COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



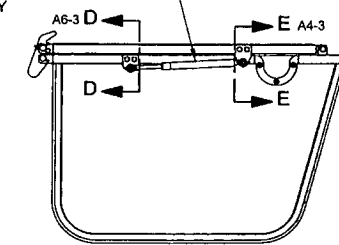
D2530
HANDLE WELDMENT



SEE
SECTION C-C
C3-3

D4030-041: D3914-041 LID ASSY
D4030-043: D3915-041 LIGHT LID ASSY

D3969-3 SPRING



D3913-041
LONG BASKET BASE ASSY

D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

